

PHI - Cms/ape Blach - ship Nov. 20!

Work Order ID 125634

October-17-14 10:18:23 AM

125634

Page 1

Item ID: D2842-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Step Assembly, 206 Float

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00

1

Cost Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2842	Rev B								

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Fig. DTS271 as per Dwg D2842 ***DO NOT OPEN HOLES**

3-Deburr and bevel ends for welding

DO NOT DRILL HOLES FOR INSERTS *off*

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

*1**

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24
9-89

Dh 14/10/27

1x

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Item ID: D2842-041

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N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Assembly, 206 Float

Start Date: 10/17/14

Start Qty: 1.00

1

Cost Item ID:

Required Date: 11/07/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Weld per dwg. A/R Aluminum rod Batch: 128756

0.00

120

Large Fab

Large Fab

Memo

0.00

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Large Fab

1-Weld one end cap and (2) lugs using Jig DT10038 as per Dwg D2842

2-Grind end cap weld flush

3-Open hole as per dwg and deburr DO NOT OPEN HOLES FOR INSURTS

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

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Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

14-10-29

DAS

9

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Quality Control

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Item ID: D2842-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Stop Assembly, 206 Float

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
Hand Finish	Memo	0.00							12 of 100
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00							1 of 11-6
Quality Control									
170	Weld per dwg A/R Aluminum rod Batch: 128956	0.00							
170	Large Rib								
Large Rib	Memo	0.00							
Large Rib	1-Remove alodine prior to welding. Weld and cap as per Dwg D2842. 2-Grind end cap weld flush.								

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Item ID: D2842-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly, 206 Float

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC10- Inspect visual per QSI004- ground welds	0.00						DAS 43 9-89	NOV 10 2014
180									
QC	Memo	0.00							
Quality Control									
190	QCS- Inspect part completeness to step on W/O	0.00						DAS 43 9-89	NOV 10 2014
190									
QC	Memo	0.00							
Quality Control									
191	Pressure Wash per QSI005 4.3	0.00							
191									
HandFinish	Memo	0.00							
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								

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Item ID: D2842-041

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Setup Start *NS1*

Revision ID:

Item Name: Step Assembly, 206 Float

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
205		0.00							DAS 41 9-89
205									
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND OSI 005 4.2 USE: PRC Desoto Primer 515X349 (Boeing Spec BMS 10-79 Type III Class A Grade A) 128975								14-11-16
	2-SPRAY PAINT PER OSI USE: CA 8213/F37038 CAMOFLAGE BLACK - MIL-PRF-05285E, TYPE 1, CLASS H 130804								
215	QC14- Inspect Spray Paint	0.00							
215									
QC	Memo	0.00							
Quality Control									

1 x f 90 46/14 DAS
15
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Item ID: D2842-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Step Assembly, 206 Float

Stop

NS2

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
220	HandFinish	0.00							
Hand Finishing	Memo	0.00							
	1-Install inserts as per Dwg D2842								
	2-Wing Walk as per Dwg D2842 and QSI 005 4.1								
	Batch: 1130259								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									
240	Identify as per dwg & Stock Location:	0.00							
240									
Packaging	Memo	0.00							
Packaging									

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38
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NOV 24 2014

DAS
C3
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Item ID: D2842-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Step Assembly, 206 Float

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Measure	0.00							
Quality Control									

MLJ 14-11-24

u 14.11.24

Picklist Print

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Work Order ID: 125634

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 10/17/14

Required Date: 11/07/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

120

Each

47.0000

1

1

D2622-120C

Step Extrusion

**

Dh 14/10/27

Location

Loc Qty

Loc Code

HALL

43

109575

32

119621

11

WA003

4

101765

1

115141

3

D2734

Manufactured No

120

Each

33.0000

2

2

D2734

Step End Plate

**

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Location

Loc Qty

Loc Code

WA003

33

118286

21

119498

11

99709

1

D3459-1

Manufactured No

220

Each

3.0000

2

2

D3459-1

Float Step Mounting Plate

**

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DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

3

113244

2

121120

1

124893 → 2

Picklist Print

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Work Order ID: 125634

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

125634

D2842-041

Start Date: 10/17/14

Required Date: 11/07/14

Start Qty: 1.00

Required Qty: 1.00

D2459-3

Manufactured No

120

Each

30.0000

2

2

D3459-3

Float Step Mounting Plate

☆☆

OCT 28 2014

DAS

24

9-89

Location

Loc Qty

Loc Code

WA003

30

116810

10

124190

20

~~\$116810~~

\$124190 →

2

MS27039C1-07

Purchased

No

220

Each

91.0000

3

3

MS27039C1-07

SCREW

☆☆

Location

Loc Qty

Loc Code

ST288

91

124588

3

m127305

15

m128401

23

m130566

50

NAS1149C0332R

Purchased

No

100

Each

8,749.000

3

3

NAS1149C0332R

WASHER

☆☆

Location

Loc Qty

Loc Code

CA

83

m129682

83

ST278

8666

122063

41

125654

425

m128319

51

m127306

2065

m127831

26

m128591

75

m129499

191

m130325

4792

m130466

1000

N/A

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Shop Packet Print

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Picklist Print

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Work Order ID: 125634

Parent Item: D2842-041

Parent Item Name: Strp Assembly, 206 Float

125634

D2842-041

Start Date: 10/17/14

Required Date: 11/07/14

Start Qty: 1.00

Required Qty: 1.00

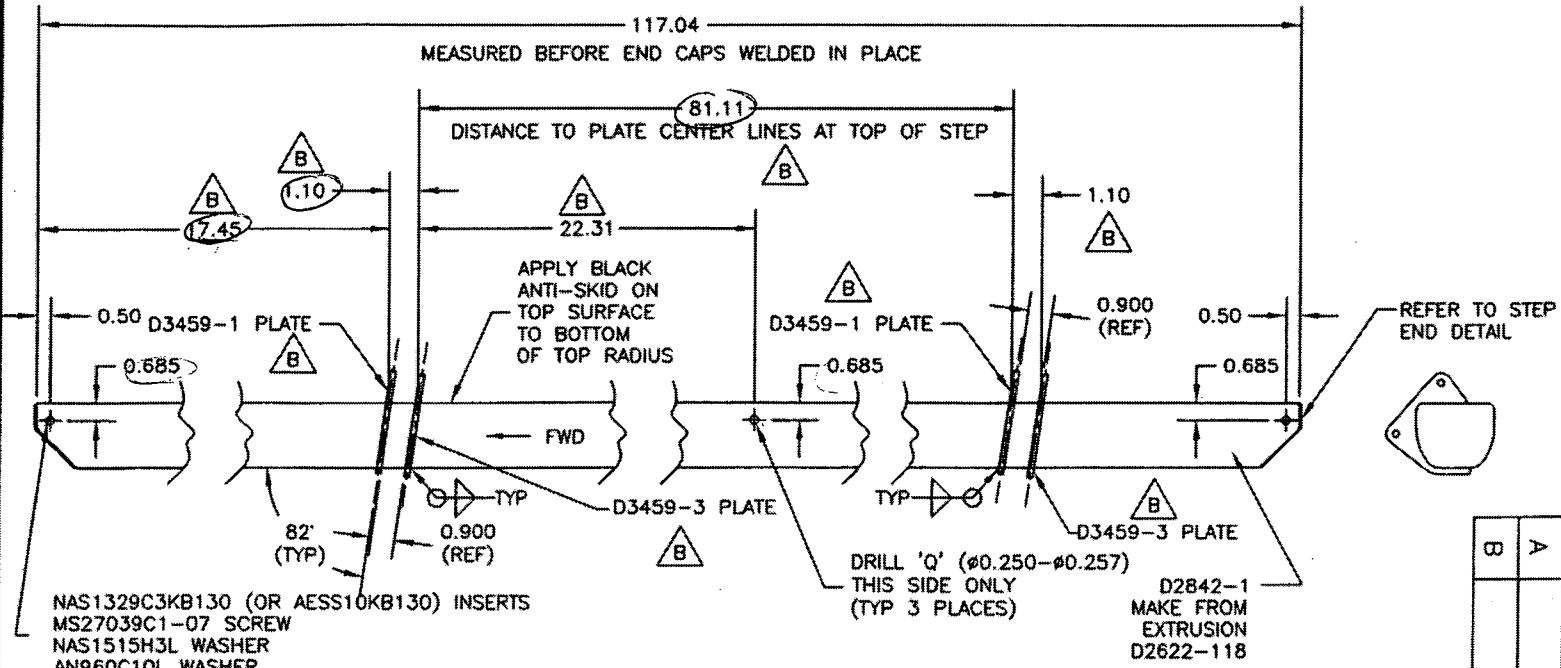
NAS1329C3KB130	Purchased	No		220	Each	82.0000	3	3
NAS1329C3KB130							**	
Insert								
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
			FP001		61			
			m127836		11			
			m130281		50			
			ST		21			
			m129207		21			
NAS1515H3L	Purchased	No		220	Each	265.0000	3	3
NAS1515H3L							**	
Washer								
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
			FG		40			
			102472		40			
			ST273		225			
			m127831		136			
			m128976		89			

N/A
NOT REQUIRED
#

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Shop Packet Print

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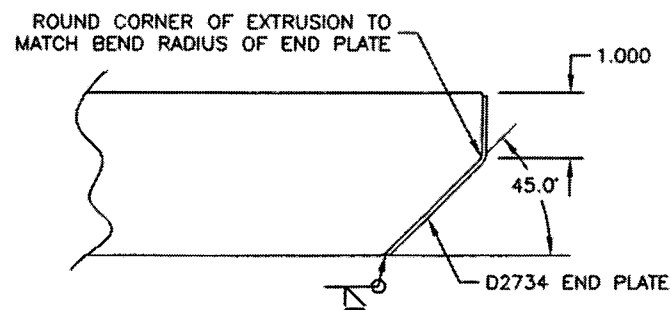
NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05/11/14

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23			D2842
	A	98.10.13		DRAWING NO.
	B	05.09.23		RE-DESIGN, ADD D3459-1/-3
				206L/407 FLOAT STEP ASSEMBLY
				NEW ISSUE
				SHEET 1 OF 1
				SCALE
				NTS

WLB 125624

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